Item ID:	D3562-041			Accept		*N9000040100*		Setup	Start	*NS1*
Revision ID:									Stop	*NS2*
Item Name:	Step Weldment									
Start Date:	5/12/14	Start Qty:	4.00	*4*		Cust Item ID:				
Required Date:	5/12/14	Req'd Qty:	4.00	*4*		Customer:				
Reference:										

Approvals: Process Plan: __MCJ__   Date: __14-05-12__ Tooling: _____   Date: _____

QC: _____   Date: _____   SPC (Y/N): _____   Date: _____

Run   Start   *NR1*

Stop   *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3562	F								
100 *100* Large Fab Large Fab	Large Fab	0.00				4	0		
	Memo 1-Cut D2622 extrusion as per Dwg D3562 2-Deburr and bevel ends for welding	0.00							14·06·04
110 *110* QC Quality Control	QC6- Inspect dimensions to drawing	0.00				4		14.06.4	DAS 24 9-89
	Memo	0.00							
120 *120* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1	0.00				4		DMC 14-6-6	
	Memo	0.00							

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____ Work Order update only ☐

| Work Order: _____ Part No. _____ NCR No. _____ | **DISPOSITION** | **AGAINST DEPARTMENT/PROCESS** |

DISPOSITION
- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS
- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear
- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General
- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function

- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence

- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge

- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____
_____

Item ID:	D3562-041	Accept	***N9000040100***	Setup Start ***NS1***
Revision ID:				
Item Name:	Step Weldment			Stop ***NS2***

Start Date:	5/12/14	**Start Qty:** 4.00	***4***	**Cust Item ID:**	
Required Date: 5/12/14		**Req'd Qty:** 4.00	***4***	**Customer:**	
Reference:					

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC7-Inspect Chemical Conversion Coat	0.00 *ZB*							DAS
130		*14/6/18*							19
QC	Memo	0.00				(4)	_____	_____	9-89
Quality Control									
140		0.00							
140	Small Fab					(4)	_____	_____	DMC
Small Fab	Memo	0.00							14-6-19
Small Fab	1- Transfer drill Rivet holes as per dwg D3562.								

2-Touch-up rivet holes with alodine as per dwg d3562

3-Rivet legs using Scotch-Weld as per dwg D3562.

******Ensure to wipe off any exess magnobond ******

A/R   Scotch-Weld DP460
Batch: *129414*
EXP DATE: *August 10 2015*

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: _____ Date: _____   Work Order update only ☐

Work Order: _____	**DISPOSITION**		**AGAINST DEPARTMENT/PROCESS**			
Part No. _____	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
NCR No. _____	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	**General**			
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions	☐ Pressure/Forced
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance	☐ Set-up
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware	☐ Part Incorrect	☐ Temperature/Cure
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☐ Part Lost/Missing	☐ Weld
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear	☐ Part Moved	☐ Wrong Stock Pulled
☐ Crushing	☐ Countersink	☐ Misaligned/off center	☐ Positioned Wrong	
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Power Loss/Surge	☐ Other
☐ Inspection Strip in Tube	☐ Drawing	☐ Misread		
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set	_____	
☐ Turning Sequence	☐ Finish	☐ Out of Calibration	_____	
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence	_____	

Item ID:	D3562-041	Accept ***N9000040100***	Setup Start ***NS1***
Revision ID:			Stop ***NS2***
Item Name:	Step Weldment		
Start Date:	5/12/14 **Start Qty:** 4.00 ***4***	**Cust Item ID:**	
Required Date:	5/12/14 **Req'd Qty:** 4.00 ***4***	**Customer:**	
Reference:			

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____   Run   Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____   Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamps
150 ***150*** QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				4	0		19 9-89 14·01·22
160 ***160*** Large Fab Large Fab	Large Fab Memo 1-Weld end caps as per Dwg d3562 & QSI 004. Inspect for foreign objects as per QSI 024. A/R Aluminum Rod *125091* 2-Grind end cap welds flush as per Dwg D3562	0.00 0.00				4x			DMC 14-07-22
170 ***170*** QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00				4			

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: _____ Date: _____   Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS				
	Rework ☐		Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐		Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐	
	Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☐		

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions	☐ Pressure/Forced
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance	☐ Set-up
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware	☐ Part Incorrect	☐ Temperature/Cure
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☐ Part Lost/Missing	☐ Weld
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear	☐ Part Moved	☐ Wrong Stock Pulled
☐ Crushing	☐ Countersink	☐ Misaligned/off center	☐ Positioned Wrong	
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Power Loss/Surge	☐ Other
☐ Inspection Strip in Tube	☐ Drawing	☐ Misread		
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set		
☐ Turning Sequence	☐ Finish	☐ Out of Calibration		
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence		

Item ID: D3562-041   Accept   *N900040100*   Setup Start   *NS1*

Revision ID:

Item Name: Step Weldment   Stop   *NS2*

Start Date: 5/12/14   **Start Qty:** 4.00   *4*   **Cust Item ID:**

Required Date: 5/12/14   **Req'd Qty:** 4.00   *4*   **Customer:**

Reference:

| Approvals: | Process Plan: _____ Date: _____ | Tooling: _____ Date: _____ | Run Start *NR1* |
| | QC: _____ Date: _____ | SPC (Y/N): _____ Date: _____ | Stop *NR2* |

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O	0.00				4			
	Memo	0.00	SHP MH7/22						
190 *190* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1	0.00				4		14-07-22 DK 7G	
	Memo	0.00							
200 *200* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 128459	0.00				4		CK 14-07-29	
	Memo START TIME: 2:00 OVEN TEMPERATURE: 220 FINISH TIME: 2:30	0.00							

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

◥DART AEROSPACE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	**DISPOSITION** Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	**AGAINST DEPARTMENT/PROCESS**

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function

- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence

- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge

- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled

- ☐ Other

_____
_____
_____

Item ID:	D3562-041		Accept	***N900040100***	Setup	Start	***NS1***
Revision ID:							
Item Name:	Step Weldment					Stop	***NS2***
Start Date:	5/12/14	Start Qty: 4.00	*4*				
Required Date:	5/12/14	Req'd Qty: 4.00	*4*	Cust Item ID:			
Reference:				Customer:			

| Approvals: | Process Plan: _____ Date: _____ | Tooling: _____ Date: _____ | Run | Start | ***NR1*** |
| | QC: _____ Date: _____ | SPC (Y/N): _____ Date: _____ | | Stop | ***NR2*** |

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 ***210*** HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch M11256 30.00					X4	4	9L	14/07 3C
	Memo	0.00							
220 ***220*** QC Quality Control	QC3- Inspect Part Finish	0.00				4X			14/08/07 DAS 36 9-89
	Memo	0.00							
230 ***230*** Packaging Packaging	Identify as per dwg & Stock Location: G·A	0.00				4X			14/08/07 DAS 36 9-89
	Memo W/O 119149	0.00							

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____   Work Order update only ☐

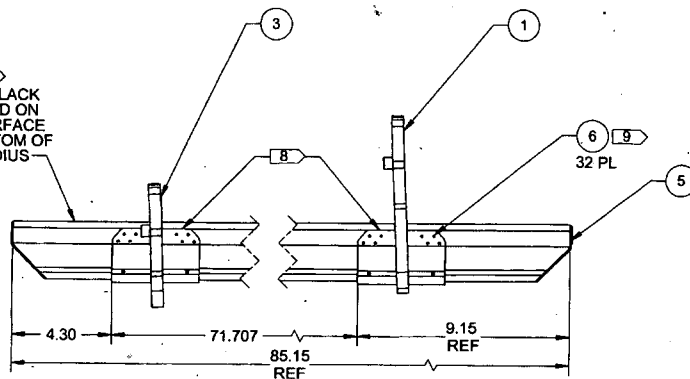| Work Order: _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS				
Part No. _____	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐		
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐		
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
NCR No. _____	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions	☐ Pressure/Forced
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance	☐ Set-up
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware	☐ Part Incorrect	☐ Temperature/Cure
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☐ Part Lost/Missing	☐ Weld
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear	☐ Part Moved	☐ Wrong Stock Pulled
☐ Crushing	☐ Countersink	☐ Misaligned/off center	☐ Positioned Wrong	
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Power Loss/Surge	☐ Other
☐ Inspection Strip in Tube	☐ Drawing	☐ Misread		
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set	_____	
☐ Turning Sequence	☐ Finish	☐ Out of Calibration	_____	
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence	_____	

Work Order ID: 119151

Parent Item: D3562-041

Parent Item Name: Step Weldment

119151
D3562-041

Start Date: 5/12/14   **Required Date:** 5/12/14

Start Qty: 4.00   **Required Qty:** 4.00

| D3560-043 | Manufactured | No | | 140 | Each | 5.0000 | 1 | 4 |

D3560-043
Arm Weldment

** ** *14·06·04*

Location	Loc Qty	Loc Code
WA003	5	
105524	1	*1*
113047	2	*1*
114177	2	*2*

| MS20600-AD4W5 | Purchased | No | | 160 | Each | 312.0000 | 32 | 128 |

MS20600-AD4W5
Blind Rivet

** ** *DMC*
14·07·22

Location	Loc Qty	Loc Code
ST311	264	*128*
m127376	46	
m128429	214	
m128468	4	*no more*
WA003	48	
m125654	48	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: _____ Date: _____   Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	**DISPOSITION** Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	**AGAINST DEPARTMENT/PROCESS**

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

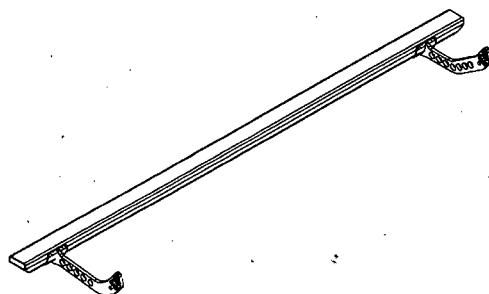| Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function

☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence

☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

_____
_____
_____

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

RELEASED
2013-06-03

2 APPLY BLACK
ANTI-SKID ON
TOP SURFACE
TO BOTTOM OF
TOP RADIUS

6 **9**
32 PL

← 4.30 → ← 71.707 → 9.15
REF
85.15
REF

MEASURED BEFORE END CAPS WELDED IN PLACE

FWD

D3562-041 LH STEP ASSEMBLY

9 **6**
32 PL

9.15
REF ← 71.707 → ← 4.30 →
85.15
REF

2 APPLY BLACK
ANTI-SKID ON
TOP SURFACE
TO BOTTOM OF
TOP RADIUS

MEASURED BEFORE END CAPS WELDED IN PLACE

FWD

D3562-042 RH STEP ASSEMBLY

NOTES:

1) MATERIAL: N/A
2) FINISH:
   i) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR
      GREY SANDTEX (4.3.5.6) OR
      BLACK SANDTEX (4.3.5.7) OR
      GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
   ii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 8.79 lbs
8) INSTALL ARM WELDMENTS WITH A LAYER OF SCOTCH-WELD DP460 BETWEEN
   THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH
   SCOTCH-WELD DP460. CLEAN OFF EXCESS BEFORE POWDER COATING.
9) TRANSFER DRILL #30 DEBURR & TOUCH UP HOLES WITH CHEMICAL
   CONVERSION COAT BEFORE RIVETING

ITEM No.	QTY -041	QTY -042	P/N	DESCRIPTION
	X		D3562-041	LH STEP ASSEMBLY
		X	D3562-042	RH STEP ASSEMBLY
1	1		D3560-041	ARM WELDMENT
2		1	D3560-042	ARM WELDMENT
3	1		D3560-043	ARM WELDMENT
4		1	D3560-044	ARM WELDMENT
5	1	1	D3562-1	STEP ASSEMBLY
6	32	32	MS20600AD4W5	RIVET
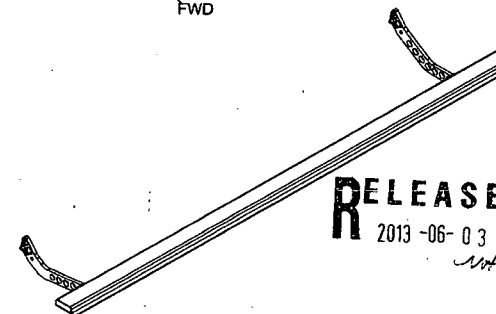
F	REVISED NOTE 8 TO REMOVE MAGNOBOND, REPLACE WITH SCOTCH-WELD DP460, REF. PAR12-224. ADDED NOTE 9 AND SHEET 2	DW	13.05.15
E	ADD QTY(2) TO D2734 END PLATE ON D3562-042	PH	08.01.11
D	REMOVE D2808 SPACER NOTE; REDRAW IN SOLIDWORKS	DC	07.11.16
C	NOW MAGNOBOND, ADD D2808, REMOVE 4 RIVETS	CP	07.06.19
B	ARMS NOW RIVETED TO STEP	CP	07.01.15
A	NEW ISSUE	CP	06.09.26
REV.	DESCRIPTION	BY	DATE

DESIGN	CP		DART AEROSPACE LTD
DRAWN	DW		HAWKESBURY, ONTARIO, CANADA
CHECKED	CP	DRAWING NO.	REV. F
MFG. APPR.		D3562	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		STEP ASSEMBLY	NTS
DATE	13.05.15	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD		

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	**DISPOSITION**	**AGAINST DEPARTMENT/PROCESS**			
Part No. _____	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
NCR No. _____	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	**General**			
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions	☐ Pressure/Forced
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance	☐ Set-up
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware	☐ Part Incorrect	☐ Temperature/Cure
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☐ Part Lost/Missing	☐ Weld
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear	☐ Part Moved	☐ Wrong Stock Pulled
☐ Crushing	☐ Countersink	☐ Misaligned/off center	☐ Positioned Wrong	
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Power Loss/Surge	☐ Other
☐ Inspection Strip in Tube	☐ Drawing	☐ Misread		
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set	_____	
☐ Turning Sequence	☐ Finish	☐ Out of Calibration	_____	
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence	_____	

DETAIL A
B4-2

85.15

2.51

D3562-1 STEP ASSEMBLY

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE

0.96

TYP 2 PL

(2)

45°

(8)   (1)
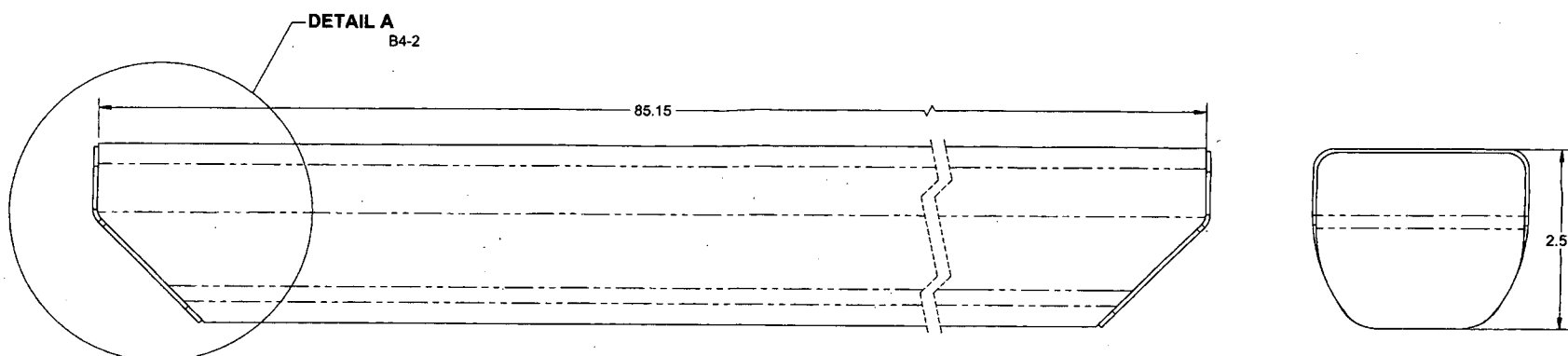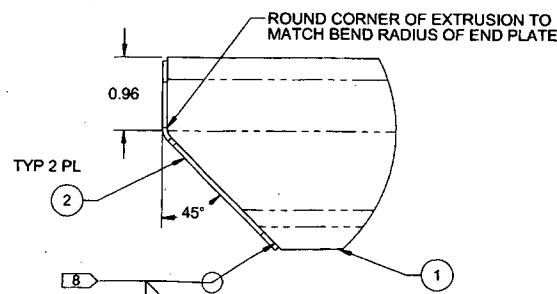
DETAIL A
C7-2
TYP BOTH ENDS
SCALE 1X

NOTES:

1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT STEP EXTRUSION
         PER DART QSI 005 4.1 BEFORE ASSEMBLY
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 6.68 lbs
8) WELDING: ALL WELDS SHALL BE 100% VISUALLY INSPECTED
         BY A QUALIFIED INSPECTOR PER DART QSI 004

ITEM No.	QTY -1	P/N	DESCRIPTION
	X	D3562-1	STEP ASSEMBLY
1	A/R	D2622-XXX	STEP EXTRUSION
2	2	D2734	END PLATE

DESIGN		DART AEROSPACE LTD
DRAWN	DW	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		D3562
APPROVED		TITLE
DE APPR.		STEP ASSEMBLY
DATE	13.05.15	

DRAWING NO. D3562   REV. F
SHEET 2 OF 2
TITLE STEP ASSEMBLY   SCALE NTS

DQA: _____ Date: _____

QA Closed: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: _____	**DISPOSITION**	**AGAINST DEPARTMENT/PROCESS**

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐   Crosstube ☐   Water Jet ☐   Engineering ☐
Machining ☐   Small Fab ☐   Prod. Eng. Coor. ☐   Quality ☐
Thermoforming ☐   Finishing ☐   Rec/Store/Packaging ☐   Other ☐
Large Fab ☐   Composite ☐   Supplier ☐

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear

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☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
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☐ Heat Treat
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☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
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☐ Drill Holes
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☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

_____
_____
_____